

Work Order ID 67651

Tuesday, March 29, 2011 9:08:02 AM



Page 1

Item ID: D4055-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *CL*

Date: *11/03/29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4055

100



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: *MIC 3431* 0.00

Memo

1- weld D4023-7 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

11.03.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/06/24

121

Weld per dwg A/R Aluminum rod Batch: ~~M1147C3~~ 0.00

M117884

0.00



Large Fab

Memo

Large Fab*

1-Weld top D4055-1

1 0 11.06.27

122

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE11/06/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control	***Pressure Test as per dwg D4055***								
	Pressure Tested to 3.5psf								
	submerged in water tank for 2.5hrs								
130	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing	1- brush alodine on tank. No alodine inside								
140	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

11/06/28

8/10/06/28

1

1 11-6-28

1 11/06/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

M. 115128
Memo

0.00

Powder Coating

Mask prior to powdercoat

Start Time: 9:00 320"

Oven Temperature: 9:30

Finish Time: 9:30

1 11-6-29

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11-6-29

185

0.00



SprayPaint

Memo

0.00

Spray Painting

Seal inside of tank using Sloshing Sealer as per dwg

X 116 444

1 11-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per dwg

SPC 06/30 ① Pto →

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 06/30

①

220

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

W/48

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4055-041 ^{CAR # 11-54} PAR #: 11-54 Fault Category: Design NCR: Yes No DQA: NA Date: 11.07.04
11.06.06 Resolution: Re work / PAR Disposition: Repair QA: N/C Closed: ✓ Date: 11.07.05

NCR: <u>6761</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/06/30</u>	<u># 190</u>	When installing the D4008-041 splash guard it was found that there was interference with weld from the cap. And cannot be	<u>11.06.30</u>	→ Grind about 1/8" off D4008-041 (or install it fits) Re touch up Alodine + Powder coat AS PER Q57005	<u>EP</u> <u>11/06/30</u>	<u>S</u> <u>11/06/30</u>	<u>11.06.30</u>	<u>S</u> <u>11/06/30</u>
		Assembled on. R.C. Design - CONGR	<u>11.06.30</u>	→ open PAR to Adjust Dim in Drawing to solve Problem.	<u>NA</u> <u>11.07.04</u>	<u>CAR</u> <u>11-54</u> <u>lk.</u>	<u>11.06.30</u>	<u>S</u> <u>11/06/30</u>

NOTE: Date & initial all entries

Work Order ID 67651

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Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	Identify as per dwg & Stock Location: _____	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
240	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

11/6/30 (1)

11/6/30 (1)

11-06-30 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 9:07:54 AM

Page 1

Work Order ID: 67651

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Start Date: 3/29/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1 Placard		Manufactured	No				Each	1.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				1					
					55400			1					
D3997-5 Placard		Manufactured	No				Each	7.0000		2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				7					
					65436			7					
D3997-11 Placard		Manufactured	No				Each	10.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				10					
					65124			10					
D3997-17 Placard		Manufactured	No				Each	10.0000		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST104				10					
					55410			1					
					65125			9					

EP 11/06/30
B68930 (R)

EP 11/06/30

2
EP 11/06/30

1
EP 11/06/30

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Tuesday, March 29, 2011 9:07:55 AM

Page 2

Work Order ID: 67651

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/29/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

D3997-29 Manufactured No

Each 10.0000



Placard



1
EPH/06/30

Location

Loc Qty

Loc Code

ST104

10

55416

1

65126

9

D3997-43 Manufactured No

Each 10.0000



Placard



1
EPH/06/30

Location

Loc Qty

Loc Code

ST104

10

65127

10

D3999-7 Manufactured No

Each 4.0000



Corner



1
K11.06.24

Location

Loc Qty

Loc Code

ENG

4

55645

4

D3999-9 Manufactured No

Each 3.0000



Angle



1
K11.06.24

Location

Loc Qty

Loc Code

WA013

3

55646

3

D3999-11 Manufactured No

Each 3.0000



Earth Tab



1
K11.06.24

Location

Loc Qty

Loc Code

WA013

3

55863

3

Tuesday, March 29, 2011 9:07:55 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 9:07:56 AM

Work Order ID: 67651

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/29/2011

Required Date: 4/12/2011

Start Qty: 1.00


Required Qty: 1.00

✓ D3999-041

Manufactured No

Each 2.0000

1


Baffle Assembly, Aft



11.06.24

Location

Loc Qty

Loc Code

WA014

2

65437


2

✓ D3999-043

Manufactured No

Each 2.0000

1


Baffle Assembly, Fwd



11.06.24

Location

Loc Qty

Loc Code

WA014

2

65439

2

✓ D4000-1

Manufactured No

Each 5.0000

1


Fuel Supply Fitting



11.05.02

Location

Loc Qty

Loc Code

WA013

5

65716

5

✓ D4000-5

Manufactured No

Each 3.0000

1


Fuel Tank Vent Fitting



11.05.02

Location

Loc Qty

Loc Code

WA013

3

65444

3

✓ D4000-9

Manufactured No

Each 5.0000

3


Grommet



11.06.24

Location

Loc Qty

Loc Code

WA013

5

65109

5

3

Tuesday, March 29, 2011 9:07:57 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

Tuesday, March 29, 2011 9:07:57 AM

Page 4

Work Order ID: 67651

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/29/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-043 ✓



Drain Fitting Assembly, Fwd

Manufactured No

Each 1.0000



1

11.05.02 365442

Location

Loc Qty

Loc Code

WA013

1

65442

1

Each 0.0000



1

11.05.02 368385 (1)

D4000-045 ✓



Fuel Pickup Fitting Assembly

Manufactured No

✓ D4000-041 ✓



Drain Fitting Assembly, Aft

Manufactured No

Each 0.0000



1

11.05.02 369096 (1)

D4001-1



Fitting

Manufactured No

Each 4.0000



1

11.05.02

Location

Loc Qty

Loc Code

WA013

4

66840

4

Each 0.0000



1

11.05.23 365445

* D4008-11



Hinge Half

Manufactured No

D4008-041



Fuel Filler Splash Guard Assembly

Manufactured No

Each 1.0000



1

Spa/06/30

Location

Loc Qty

Loc Code

ST122

1

59516

1

367637 (14)

Tuesday, March 29, 2011 9:07:58 AM

Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Tuesday, March 29, 2011 9:07:58 AM

Page 5

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Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 3/29/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4023-3.

B 70226



Cap and Flange

Manufactured No

Each 8.0000



1

11.06.22

Location

Loc Qty

Loc Code

ST110

6

64879

6

WA013

2

66862

2

D4025-1

Manufactured No

Each

8.0000



Fuel Quantity Sender



Tank Front and Bottom

Manufactured No

Each

2.0000

B65131

11



1

11/06/30

Location

Loc Qty

Loc Code

WA013

2

65447

2

D4055-9

Manufactured No

Each

6.0000



Tank Back



1

11.06.22

Location

Loc Qty

Loc Code

WA013

6

63948

1

65451

2

66842

3

D4055-7

Manufactured No

Each

2.0000



Tank Fwd End



1

11.06.22

Location

Loc Qty

Loc Code

WA014

2

65450

2

Tuesday, March 29, 2011 9:07:58 AM

Shop Packet Print

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Work Order ID: 67651

Parent Item: D4055-041


Parent Item Name: Fuel Tank Assembly

Start Date: 3/29/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4055-5

 Tank Upper Cut Out

Manufactured No

Each 2.0000

1



11.05.23

Location

Loc Qty

Loc Code

ST119

2

65449

2


Each

2.0000

1



11.05.02

✓ D4055-3

 Tank Aft End

Manufactured No

Location

Loc Qty

Loc Code

WA014

2

65448

2

Each

2.0000

1



11.05.02

✓ D4055-1

 Tank Top

Manufactured No

Location

Loc Qty

Loc Code

WA013

2

65446

2

Each

17.0000

3



11.06.24

✓ D4057-1

 Retaining Ring

Manufactured No

Location

Loc Qty

Loc Code

WA013

17

55826

17


Each

27.0000

3



4/06/30

AN3H5A

 Bolt

Purchased No

Location

Loc Qty

Loc Code

ST350

27

114941

7

116704

20

3

Tuesday, March 29, 2011 9:07:59 AM

Shop Packet Print

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 67651



Parent Item: D4055-041



Parent Item Name: Fuel Tank Assembly

Start Date: 3/29/2011

Required Date: 4/12/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0363J

Purchased

No

Each

2,056.000



Washer



5
EP 11/06/30

Location

Loc Qty

Loc Code

ST298

2056

116583

2056

1117291 (52)

D4404-1 B 70247 21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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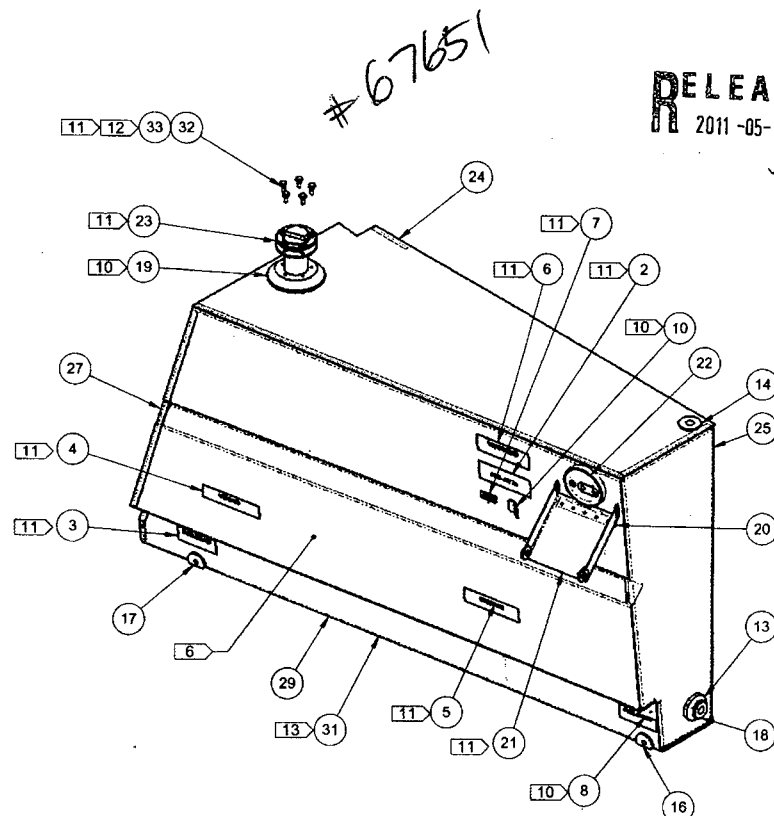
NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY



RELEASED
2011-05-30

B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.12		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B SHEET 1 OF 15
TITLE TANK	SCALE NTS

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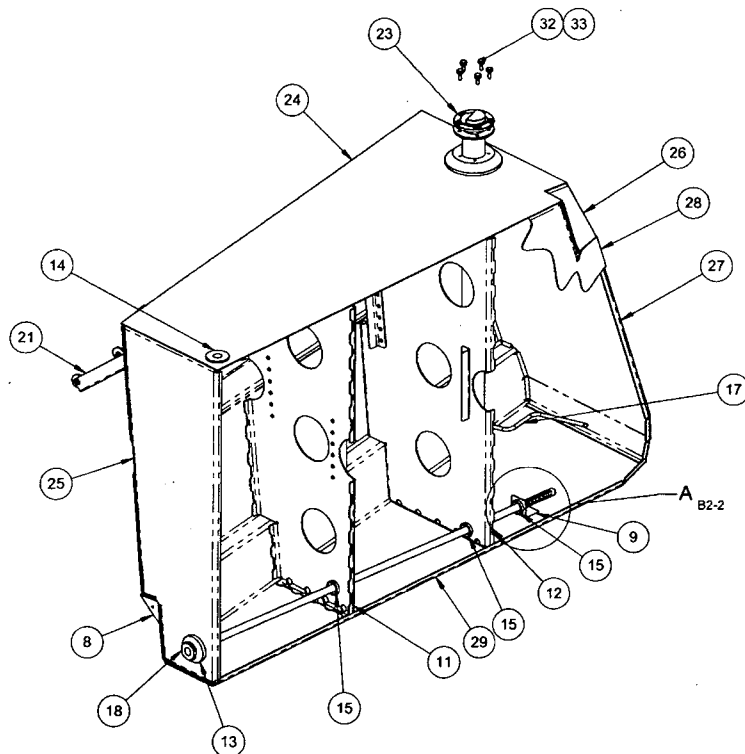
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

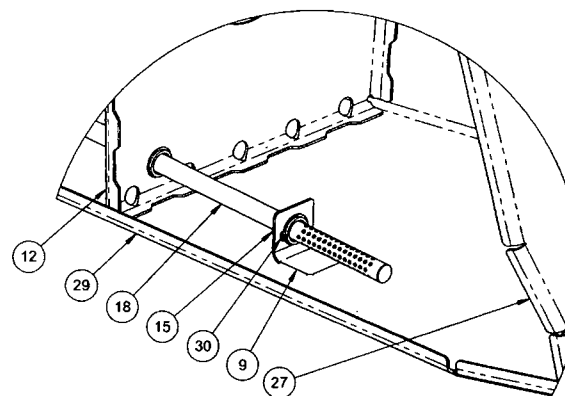
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X

B6-2

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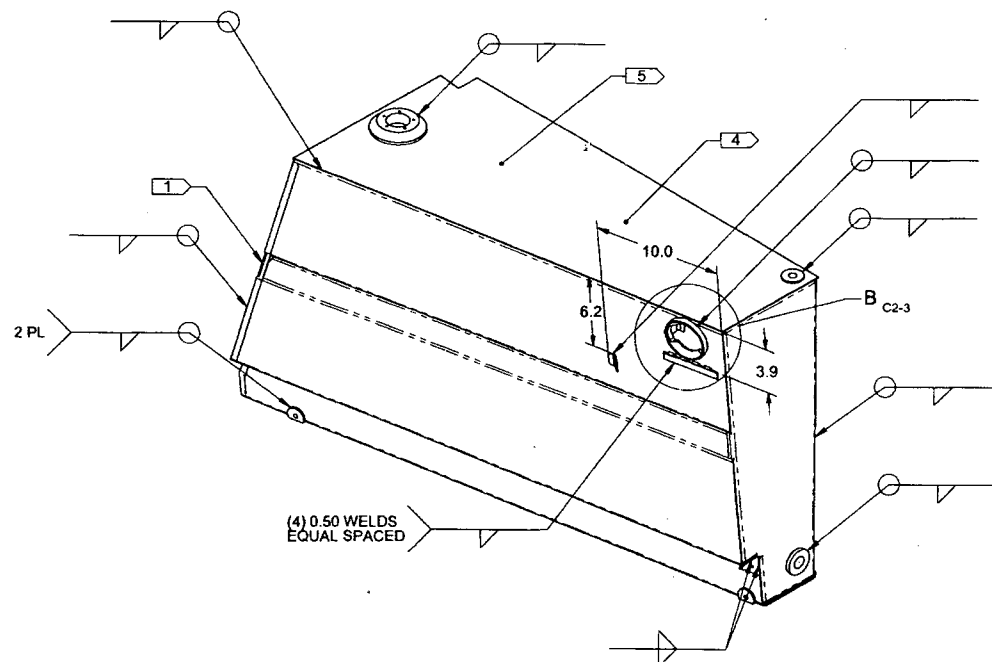
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

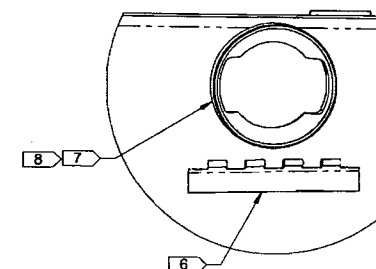
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**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK



**DETAIL B
ROTATED FOR CLARITY
SCALE 2X**

C4-3

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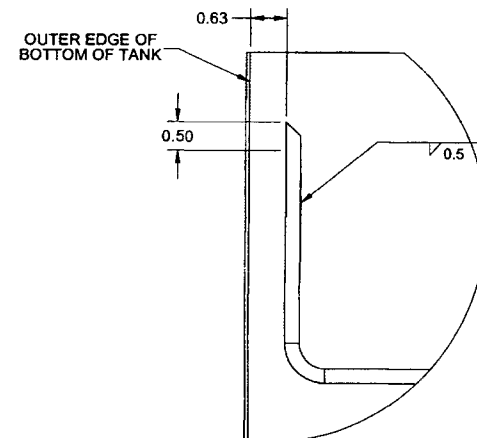
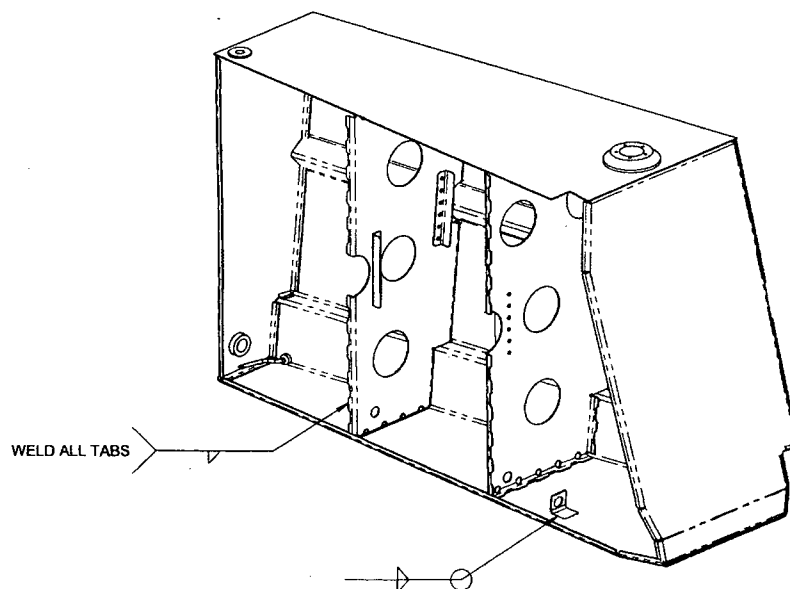
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DRAIN TUBE INSTALLATION - TYP
VIED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

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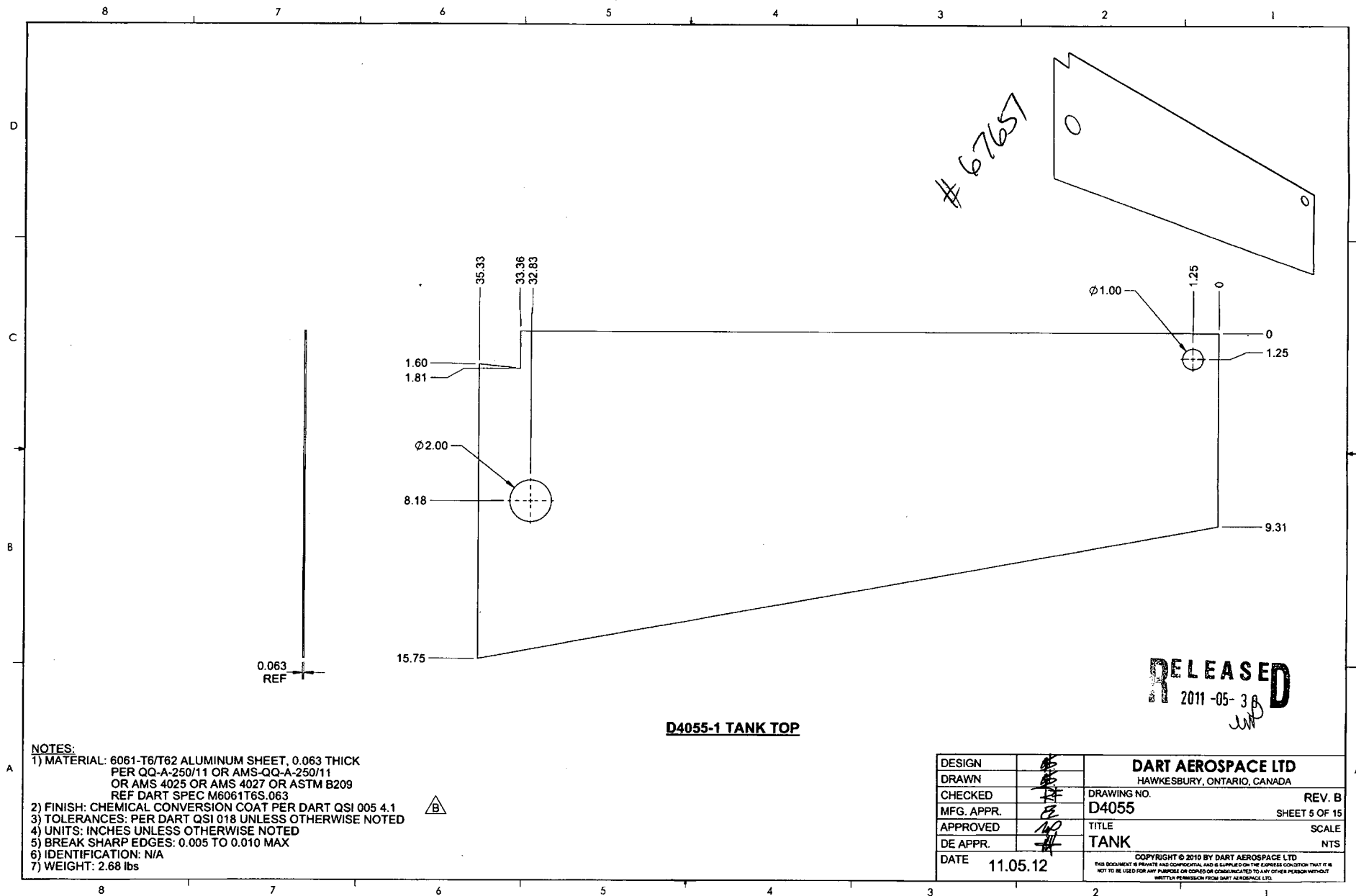
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









D4055-1 TANK TOP

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.68 lbs



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2011-05-30
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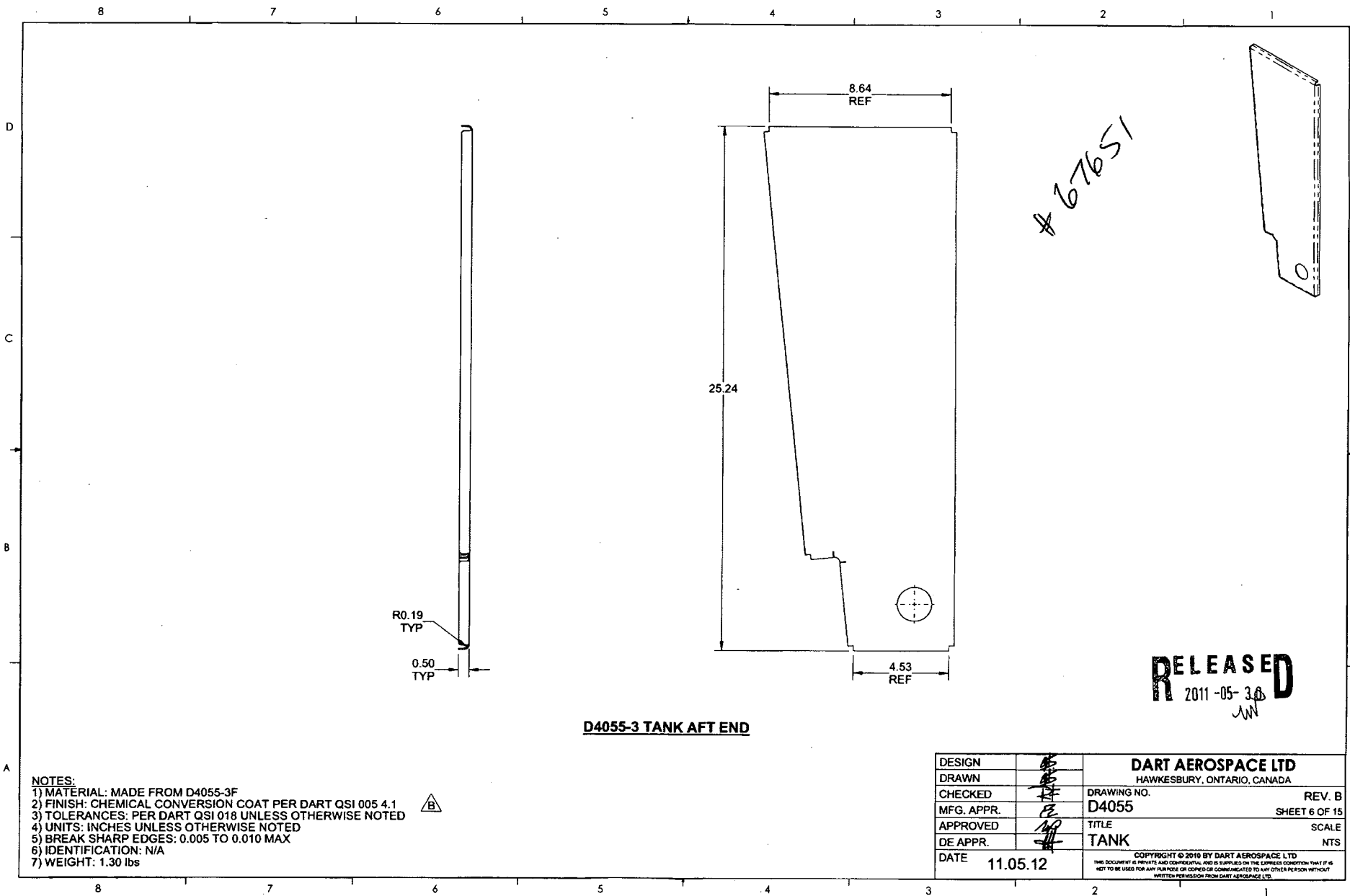
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4055-3 TANK AFT END

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs

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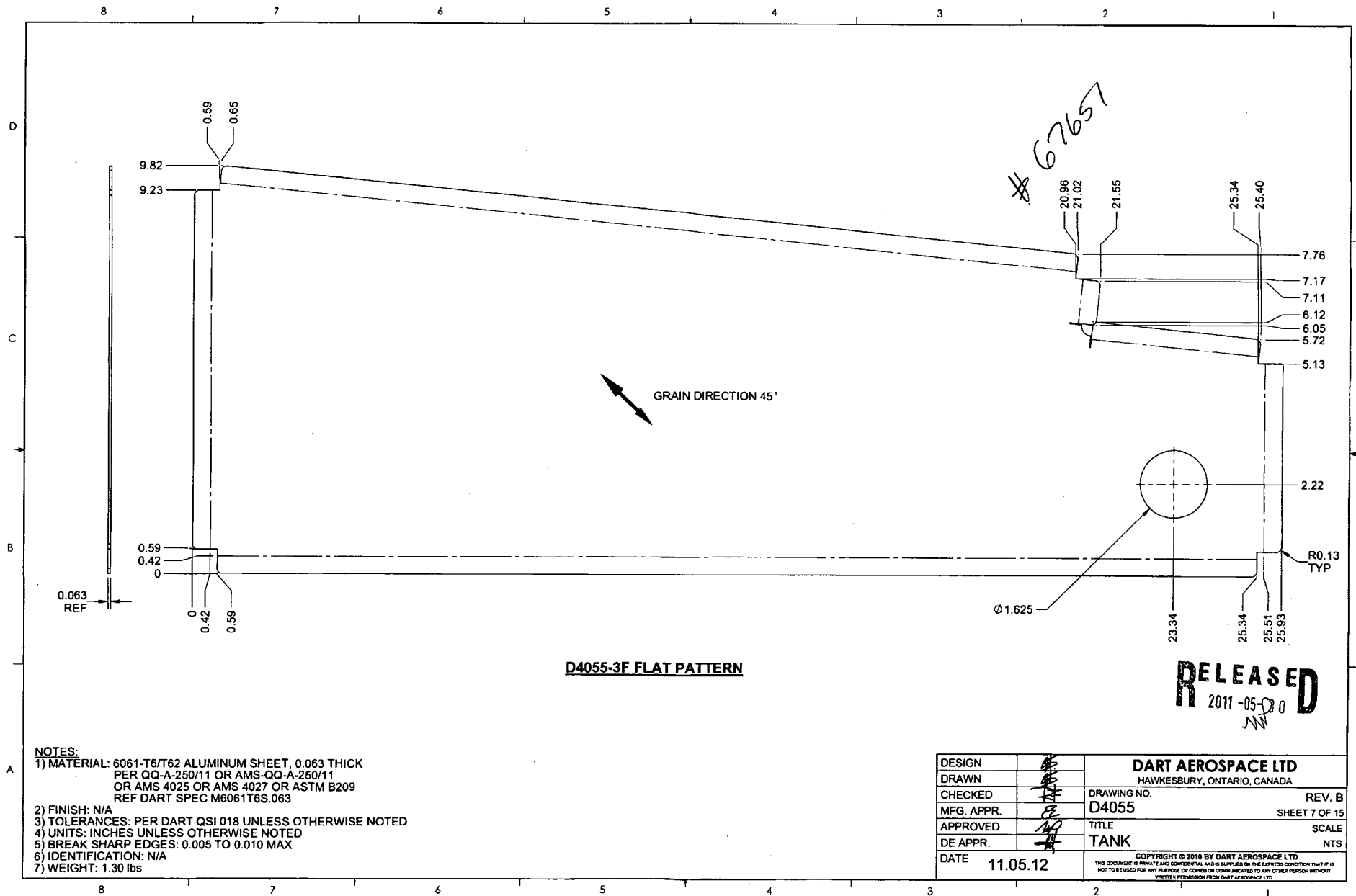
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



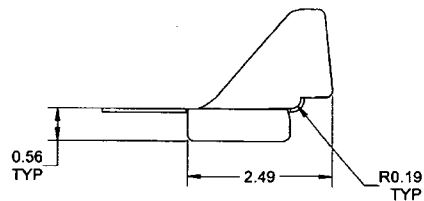
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

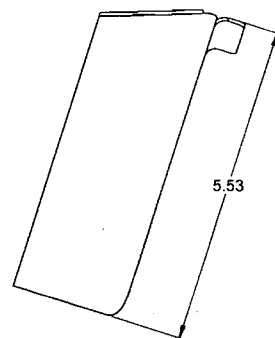
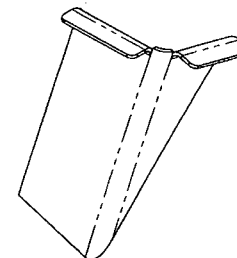
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



67651



D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
JW

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



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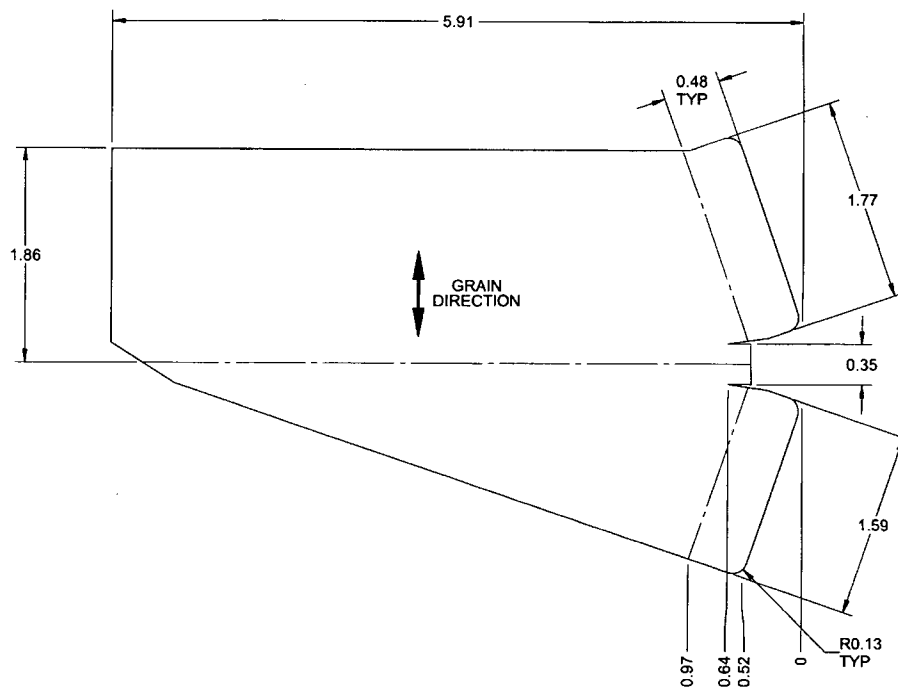
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			







NOTE: Date & initial all entries



RELEASED
2011-05-30
AM

1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.10 lbs

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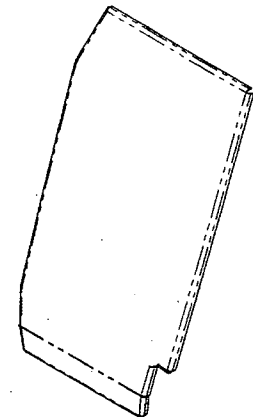
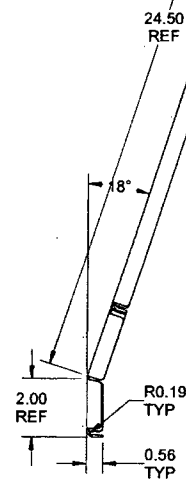
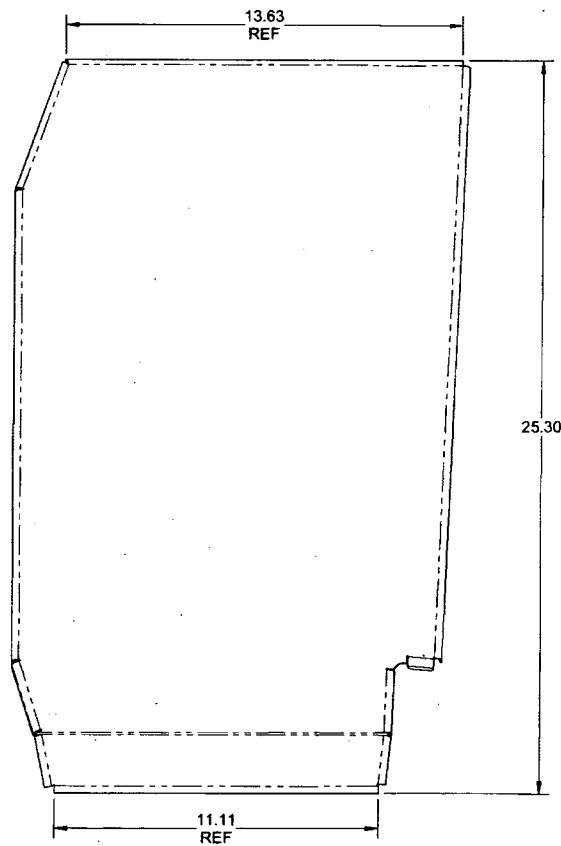
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



#6765

D4055-7 TANK FORWARD END

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-7F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.56 lbs



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2011-05-30
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

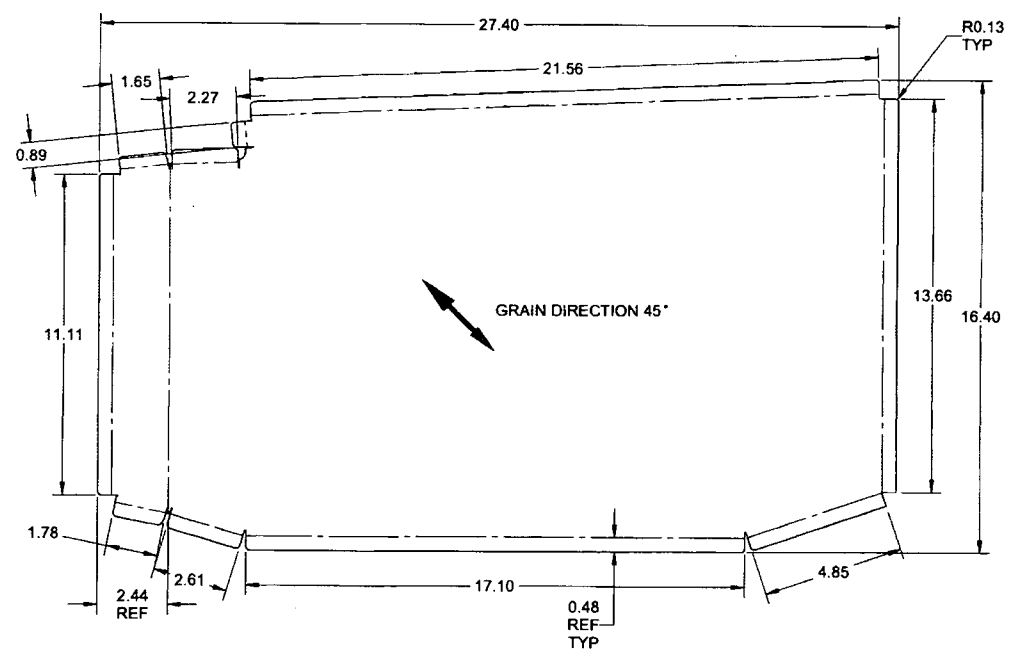
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

#67651

0.063
REF









D4055-7F FLAT PATTERN

RELEASED
2011-05-30
AW

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		DART AEROSPACE LTD	
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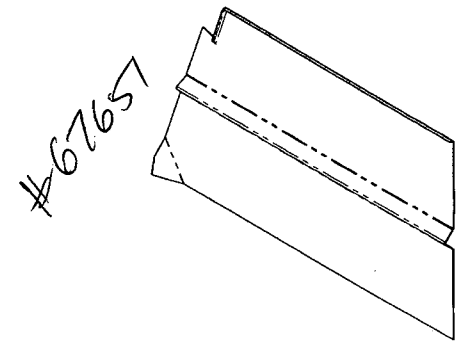
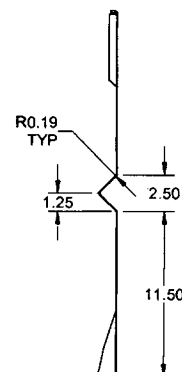
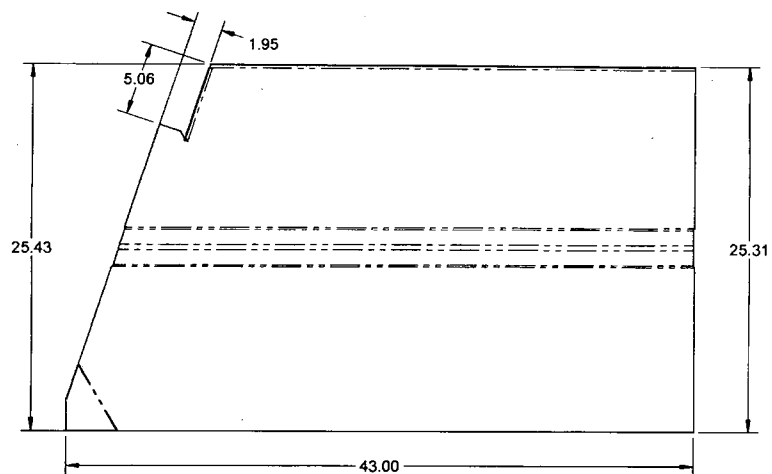
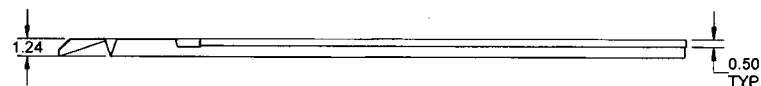
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









D4055-9 TANK BACK

RELEASED
2011-05-30
ANN

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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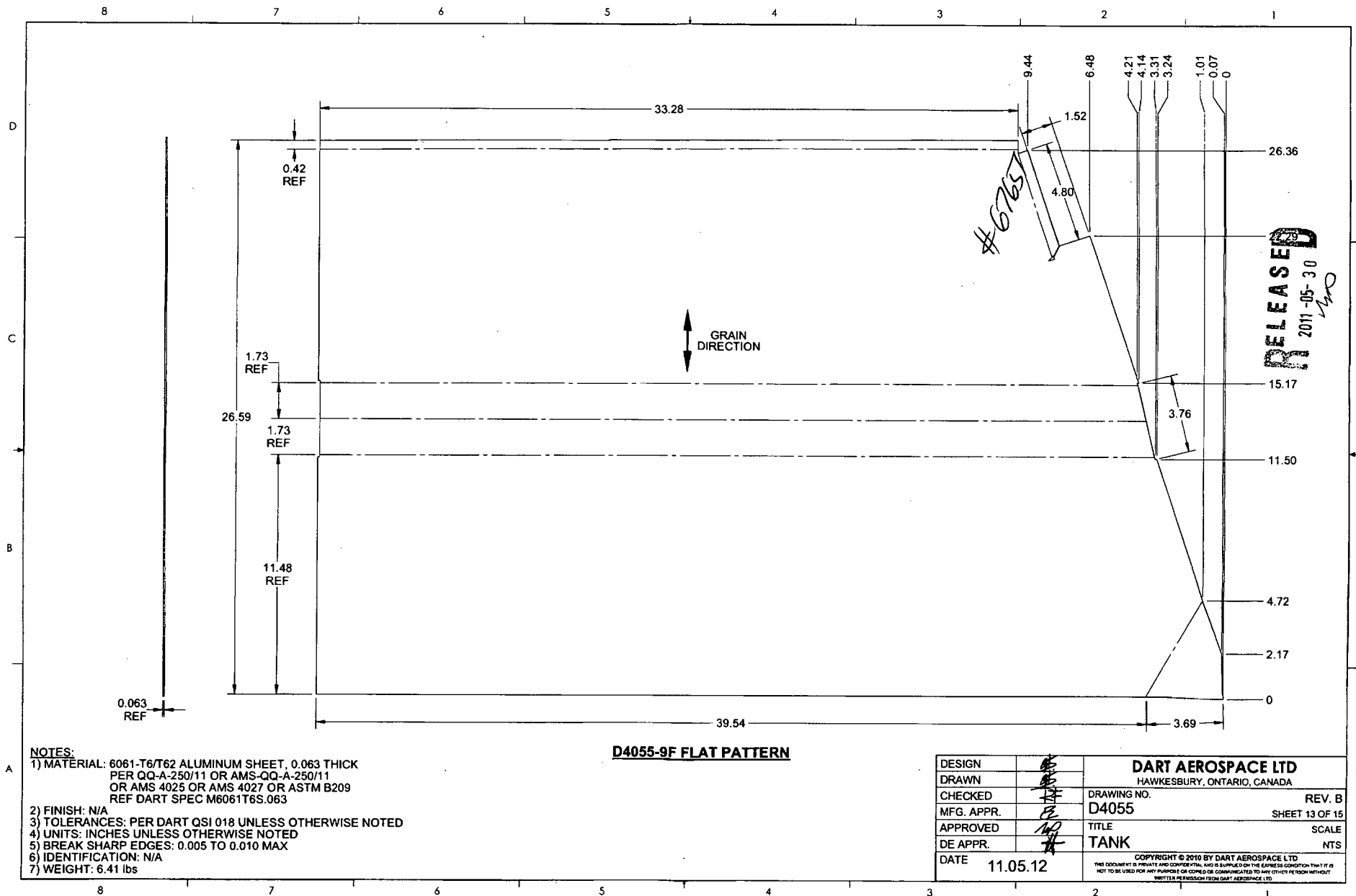
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



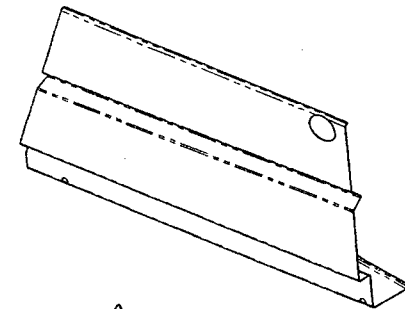
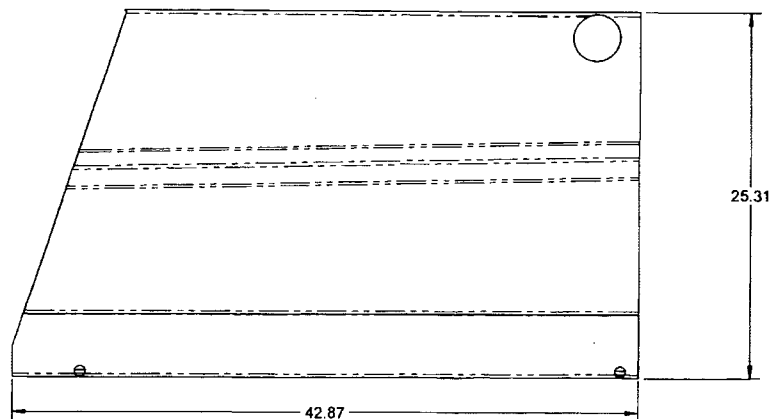
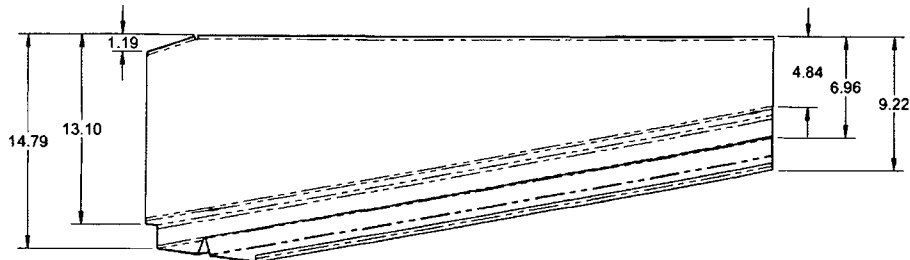
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

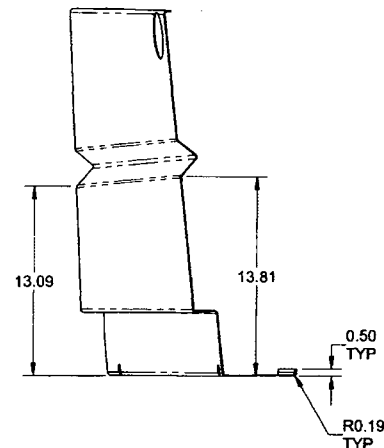
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









#67657



D4055-11 TANK FRONT AND BOTTOM

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.32 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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RELEASED
2011-05-30

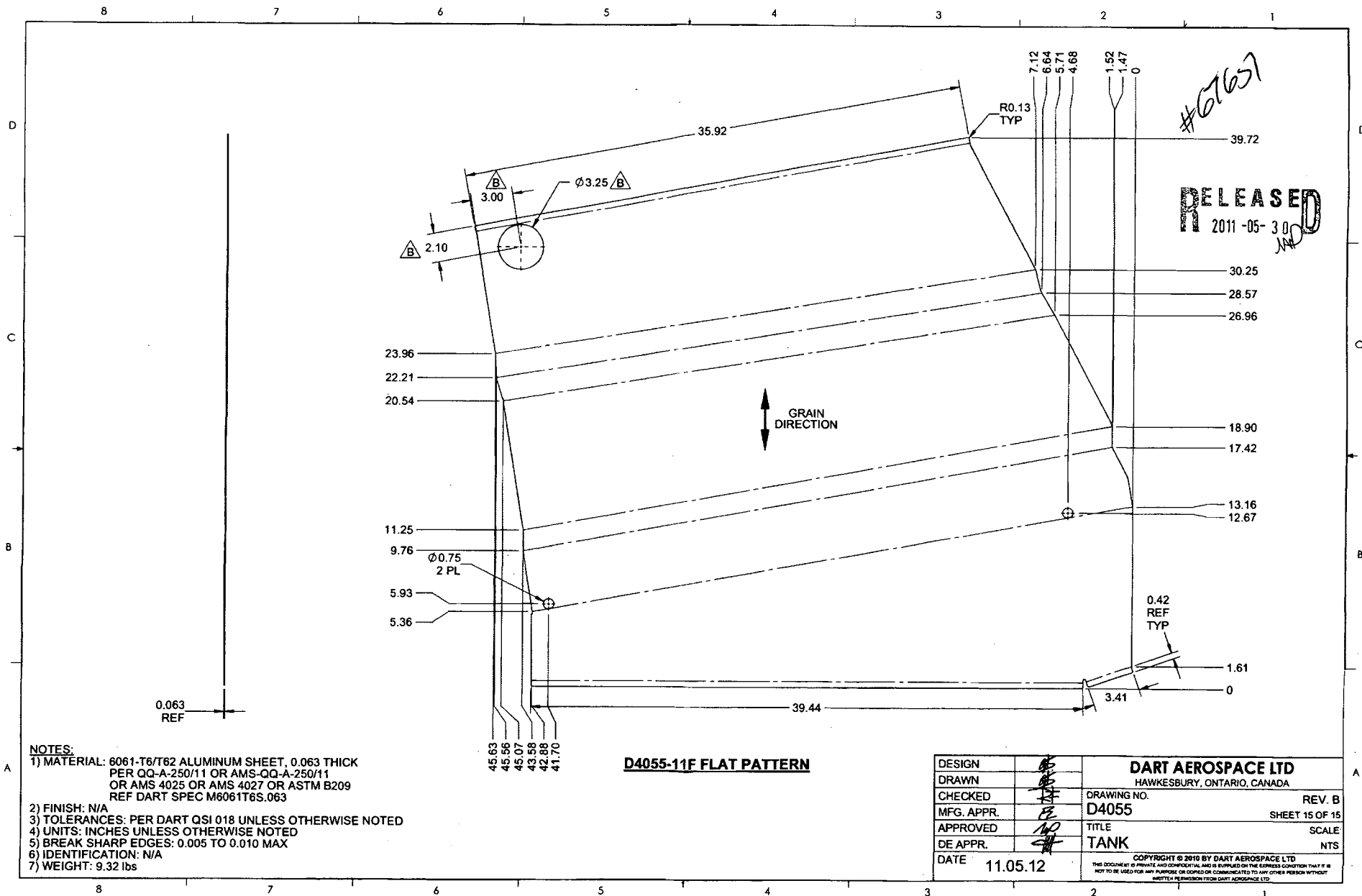
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries